

# Work Order ID 78804

January-16-12 9:03:38 AM

**\*78804\***

Page 1

Item ID: D3278-2 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Support  
 Start Date: 16/01/2012 Start Qty: 80.00 **\*80\*** Cust Item ID:  
 Required Date: 30/01/2012 Req'd Qty: 80.00 **\*80\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/01/12 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3278	Rev C

100	SHEAR	0.00							
<b>*100*</b>									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: 2.00" x 1.00" x 2.550" long								

12-02-12 **(x80)**

110	HAAS CNC VERTICAL MACHINING #1	0.00							
<b>*110*</b>									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1- Machine as per Folio FA405 and Dwg D32782- Deburr and Tumble/Identify as D3278-2								

12/03/12 **(x80)**

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

12/03/12 **(x80)**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> QC Quality Control	QC8- Inspect parts - second check.  Memo	0.00 0.00		SL 12-03-13					
140 <b>*140*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00							80X Ø M/L 12/03/14
150 <b>*150*</b> Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum  Memo START TIME: 12h50 FINISH TIME: 1h20	0.00 0.00							80 X Ø M/L 12/03/15 m120222

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 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <i>GA</i>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

80. 0 All 12/3/15

*EB* 12/03/15 (80)

12/3/14

12-03-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

January-16-12 9:03:43 AM

Page 1

Work Order ID: 78804

\*78804\*

Parent Item: D3278-2

\*D3278-2\*

Parent Item Name: Support

Start Date: 16/01/2012

Required Date: 30/01/2012

Start Qty: 80.00

Required Qty: 80.00

## Comments:

IPP: A04.04.19New issueKJ/JLM

IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased		No		100	f	26.2760	0.2337	19.68			

\*M6061T6B1 000X02 000\*

6061-T6 Bar 1.00 x 2.00

120603 x ~~5~~ 12.546 \*\* 85 12-02-19

Location	Loc Qty	Loc Code
MAT003	23.646	
112567	16.6	
118106	7.046	
MAT004	2.63	
120044	2.63	x 25 pcs

7.134

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	78804
<b>Description:</b> Support		<b>Part Number:</b>	D3278-2
<b>Inspection Dwg:</b> D3278 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.098	✓		Dim. caliper	36.05
0.359	+/-0.005	.360	✓			
0.609	+/-0.010	.612	✓			
0.250	+/-0.010	.250	✓			
1.480	+/-0.005	1.481	✓			
R0.125	+/-0.010	.125	✓			
0.119	+0.005/-0.004	.121	✓			
2.439	+/-0.010	2.442	✓			
1.980	+/-0.010	1.981	✓			
R0.13	+/-0.030	.130	✓			
Ø0.257	+0.005/-0.000	.257	✓			
R0.375	+/-0.010	.375	✓			
0.875	+/-0.010	.875	✓			
0.500	+/-0.010	.502	✓			
R0.400	+/-0.010	.400	✓			
R1.00	+/-0.030	1.00	✓			
1.720	+/-0.010	1.722	✓			
R0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.128	✓			

<b>Measured by:</b>	BB	<b>Audited by:</b>	JL	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	06-03-12	<b>Date:</b>	12-03-13	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	AF

W/O:		WORK ORDER CHANGES					
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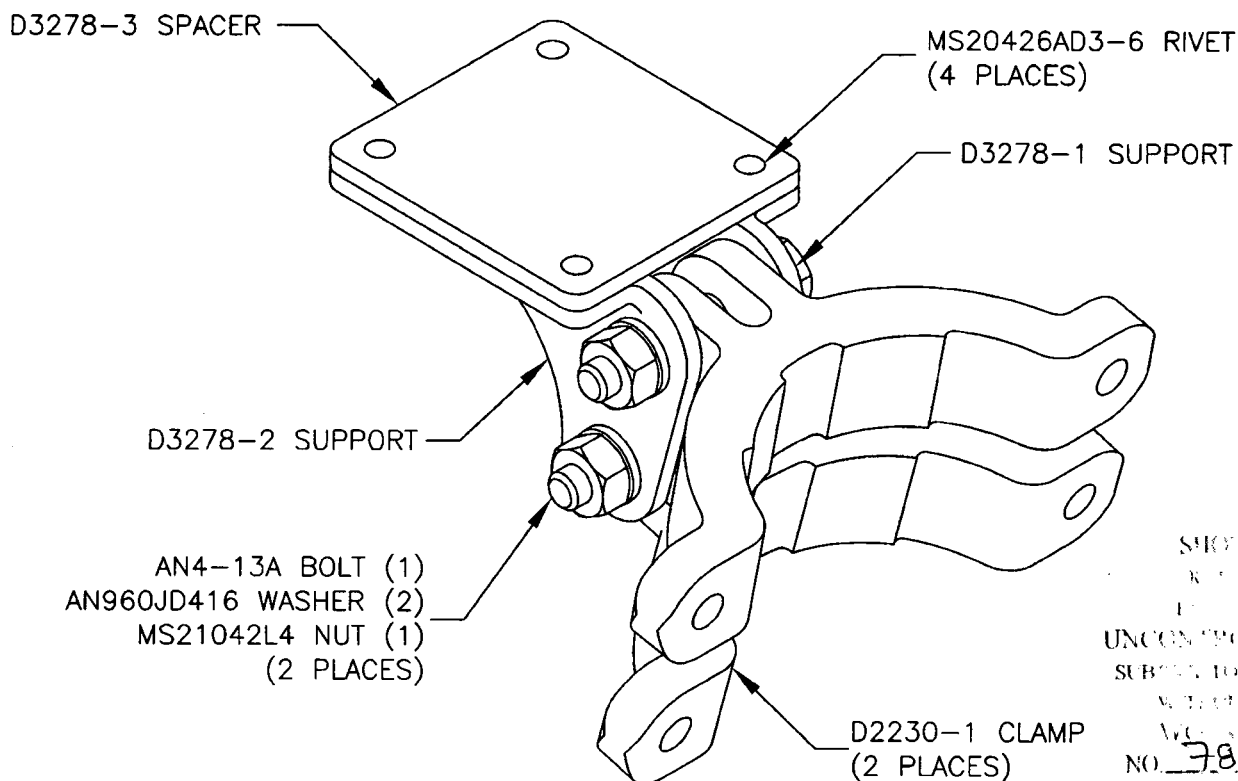
**NOTE:** Date & initial all entries

**DART**

DESIGN <i>9P</i>	DRAWN BY <i>DC</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

**RELEASED**  
*07-08-08*

## D3278-041 SUPPORT ASSEMBLY



SKY  
K  
F  
UNCONTROLLED COPY  
SUBJECT TO VERIFICATION  
NO. 78804  
M.C.J.

12/01/16

Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

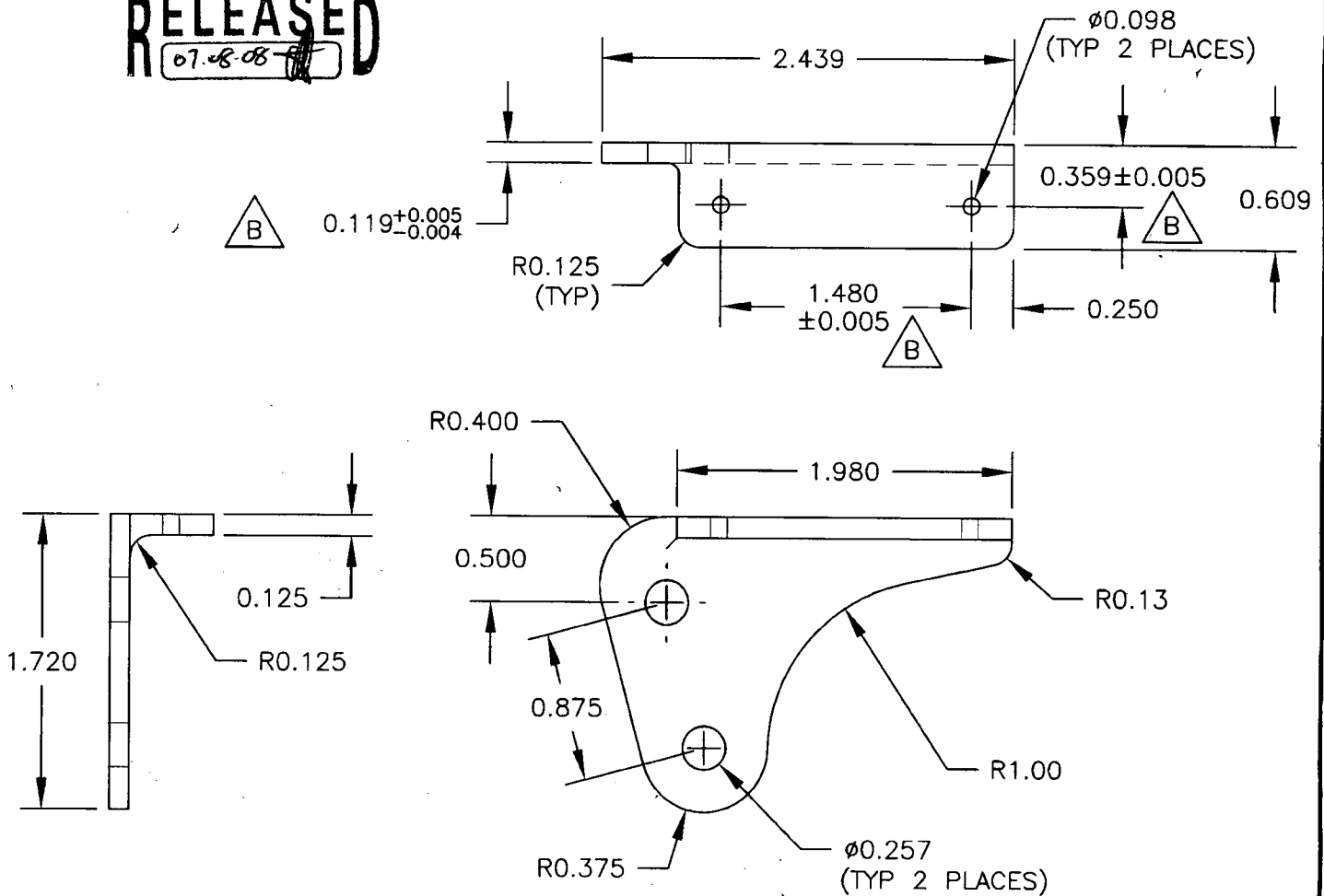
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**NOTE:** Date & initial all entries

**DART**

DESIGN 91	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

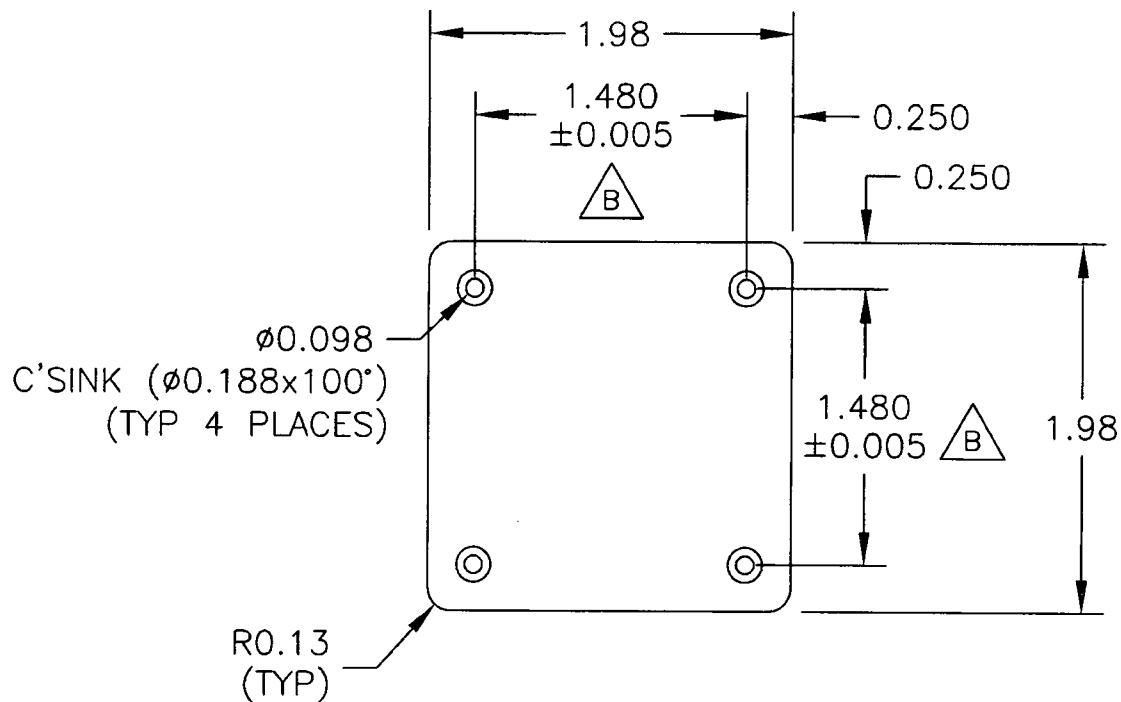
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NOTE: Date & initial all entries

**DART**

78804

DESIGN 9P1	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED [Signature]	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

**RELEASED**  
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR  
DELRIN II 150E OR ACETRON GP ACETAL  
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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